

Work Order ID 50518

July 14, 2009 7:33:44 AM

Page 1

Item ID: D206-667-101TRN

Accept

Revision ID: C

Item Name: Crosstube Turning Detail

Start Date: 7/15/09 Start Qty: 1.00

Required Date: 7/21/09 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D206-667-141

Rev C

100

0.00



Mori Seiki

MORI SEIKI CNC LATHE LARGE

Memo

0.00

Mori Seiki CNC Lathe Large

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA083□2-Turn first side as per Folio FA083□3-File down transition lines smooth.

a.m 09 - 07 - 16 ①

110

0.00



QC

QC1- Inspect dimensions to dimension sheet

Memo

0.00

Quality Control

a.m 09 - 07 - 16 ①

120

0.00



Mori Seiki

MORI SEIKI CNC LATHE LARGE

Memo

0.00

Mori Seiki CNC Lathe Large

1-Turn second side as per Folio FA083□2-File down transition lines smooth.
□
3-Remove sand and plugs

a.m 09 - 07 - 16 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 50518



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Item ID: D206-667-101TRN

Accept



Setup Start



Revision ID: C

Stop



Item Name: Crosstube Turning Detail

Start Date: 7/15/09 Start Qty: 1.00



Cust Item ID:

Required Date: 7/21/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	QC1- Inspect dimensions to dimension sheet	0.00							
QC Quality Control	Memo	0.00							Q.M. 09-07-16 (1)
140 	QC8- Inspect parts - second check	0.00							
QC Quality Control	Memo	0.00							⇒ 09/07/16 \$ (1) 6
150 	Crosstubes Chemical Conversion	0.00							
HandFXtube Hand Finishing Crosstubes	Memo	0.00							AWM 9-7-16 (1)

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Item ID: D206-667-101TRN

Accept



Setup Start



Revision ID: C

Stop



Item Name: Crosstube Turning Detail

Start Date: 7/15/09 Start Qty: 1.00



Cust Item ID:

Required Date: 7/21/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start



QC: Date: SPC (Y/N): Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

N 9-7-16.

170

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and stock in kanban rack ☐ Location:

X-TUBE CELL AM 9-7-16 ①

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/07/21 HJ

W 09.07.07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

July 14, 2009 7:33:44 AM

Page 1

Work Order ID: 50518

Parent Item: D206-667-101TRNRevC

Parent Item Name: Crosstube Turning Detail

Start Date: 7/15/09

Required Date: 7/21/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6001-105RevA		Manufactured	No			110	Each	34.0000	1.0000			



Crosstube, Material



A.M 09-09-2'

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

34

25661

5

29115

29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 50518
Description: Crosstube Assembly (206B High Fwd)		Part Number: D206-667-141
Inspection Dwg: D206-667-141 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.240	+0.005/-0.000	2.245	/			
	2.074	+0.005/-0.000	2.077	/			
	2.074	+0.005/-0.000	2.099	/			
	2.114	+0.005/-0.000	2.118	/			
	2.154	+0.005/-0.000	2.156	/			
	2.194	+0.005/-0.000	2.199	/			
	2.234	+0.005/-0.000	2.239	/			
	0.110	+/-0.010	0.110	/			
	0.300 x 30°	+/-0.010	0.300 x 30°	/			
	R0.063	+/-0.010	R0.063	/			
	R0.500	+/-0.010	R0.500	/			
	4.438	+/-0.030	4.438	/			
SIDE B	2.240	+0.005/-0.000	2.245	/			
	2.074	+0.005/-0.000	2.077	/			
	2.074	+0.005/-0.000	2.079	/			
	2.114	+0.005/-0.000	2.118	/			
	2.154	+0.005/-0.000	2.156	/			
	2.194	+0.005/-0.000	2.199	/			
	2.234	+0.005/-0.000	2.239	/			
	0.110	+/-0.010	0.110	/			
	0.300 x 30°	+/-0.010	0.300 x 30°	/			
	R0.063	+/-0.010	R0.063	/			
	R0.500	+/-0.010	R0.500	/			
	4.438	+/-0.030	4.438	/			
	93.18	+/-0.020	93.180	/			

Measured by: A.M	Audited by: S	Prototype Approval:	N/A
Date: 09.07.16	Date: 09/07/16	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.10.24	New Issue (P/O D206-667-101)	KJ/JLM	B

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Item	Qty -141	Part Number	Description
1	X	D206-667-141	CROSSTUBE ASSEMBLY (206B HIGH FWD)
2	1	D6001-105	CROSSTUBE
3	2	D2873-043	NUT PLATE
4	2	D2873-045	NUT PLATE
5	2	D2891-1	SUPPORT
6	4	D3595-063-395	RUBBER CUSHION
7	4	MS21920-20	CLAMP (OR MS21920-21)
8	14	MS20601AD4W8	RIVET (OR NAS9302B-4-8)
9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6001-105
FINISHED LENGTH = 93.18±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-141" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 11.3 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY. TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 12 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-20 CLAMPS (OR -21) WITH D3595-063-395 RUBBER CUSHIONS TO SECURE THE D2891-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS ARE LOCATED ON CROSSTUBE SUPPORTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

RELEASED
08/11/12

C	REVISE GENERAL NOTES/PART LIST (ZN D7-1); REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS. D3595-063-395 WAS D2858-400-694 (ZN D6-2 & A5-2); REMOVED REF. & ADD TOLERANCES (ZN C4-3, C5-3 & D3-3); RELOCATED FLAG #6 (ZN A8-3) PER NCR 210; MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4.	RF	08.11.06
B	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKUDTUBES	PH	05.07.26
A	NEW ISSUE	CP	00.11.17
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF	DRAWING NO.	REV. C
CHECKED	RF	D206-667-141	SHEET 1 OF 4
MFG. APPR.	RF	TITLE	SCALE
APPROVED	RF	CROSSTUBE ASSY (206B HIGH FWD)	NTS
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DATE	08.11.06		

Dart Aerospace Ltd

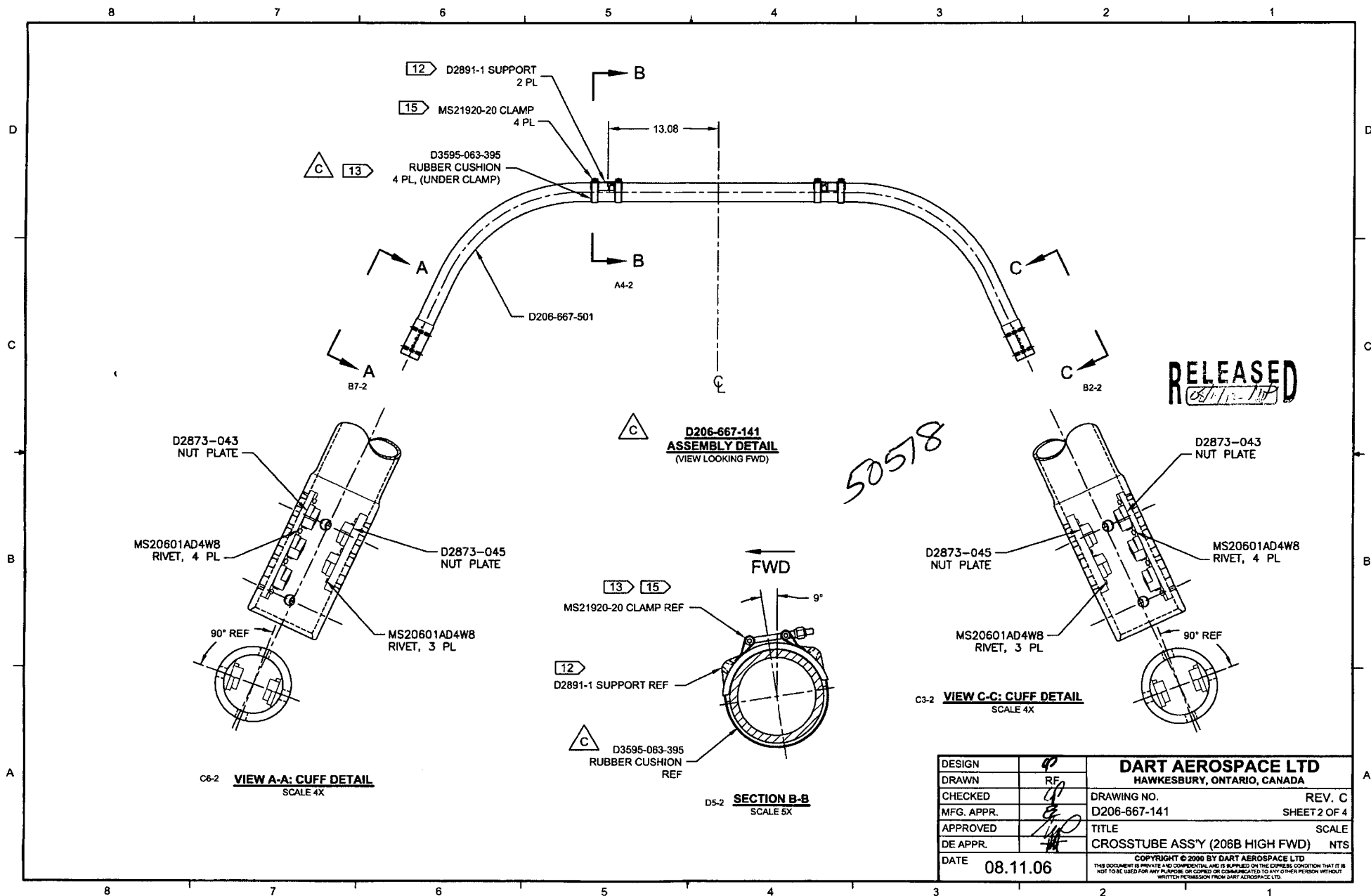
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DESIGN	90	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	CP	DRAWING NO.	REV. C
MFG. APPR.	EP	D206-667-141	SHEET 2 OF 4
APPROVED	HP	TITLE	SCALE
DE APPR.	HP	CROSSTUBE ASS'Y (206B HIGH FWD)	NTS
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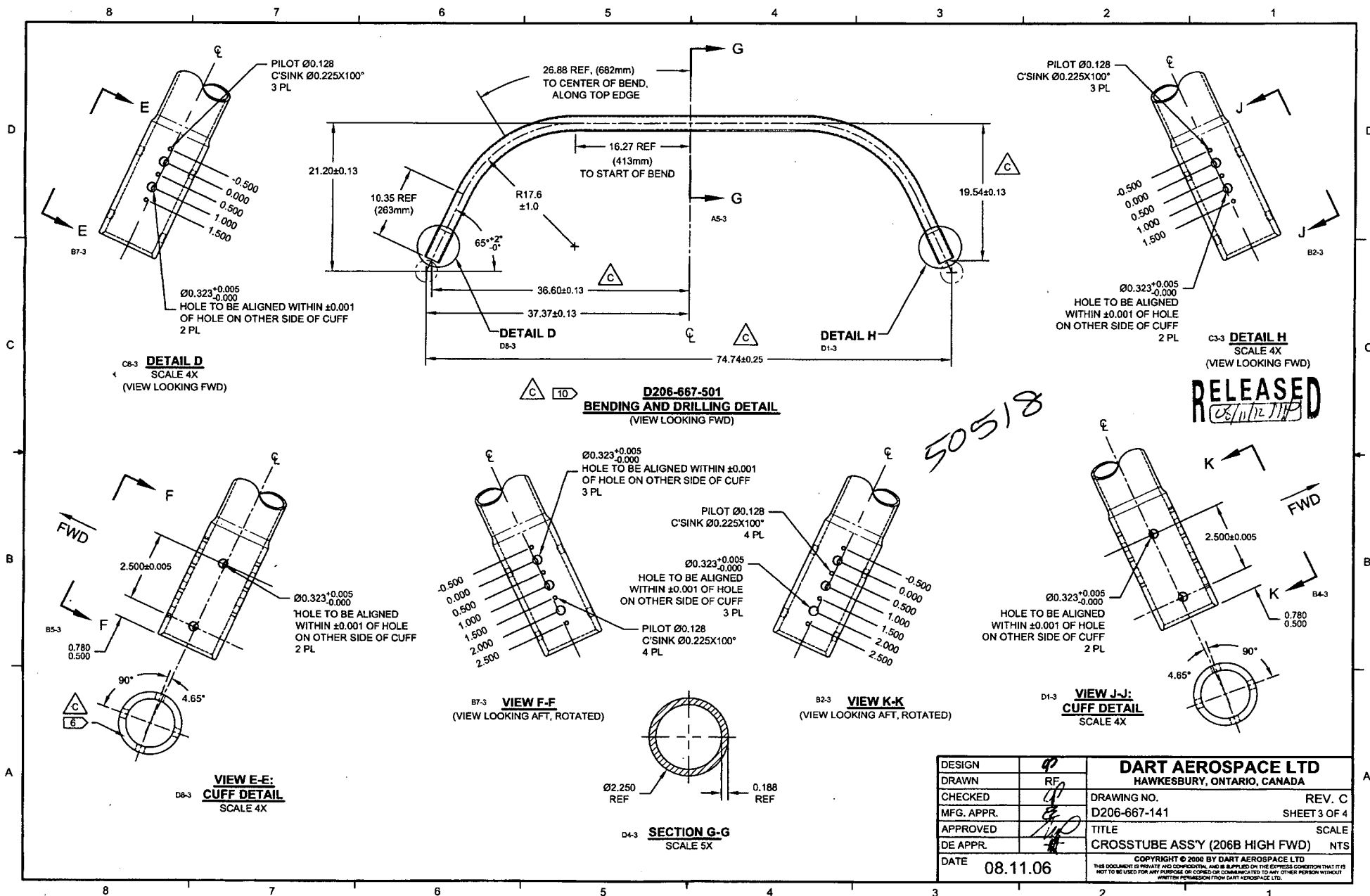
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Dart Aerospace Ltd

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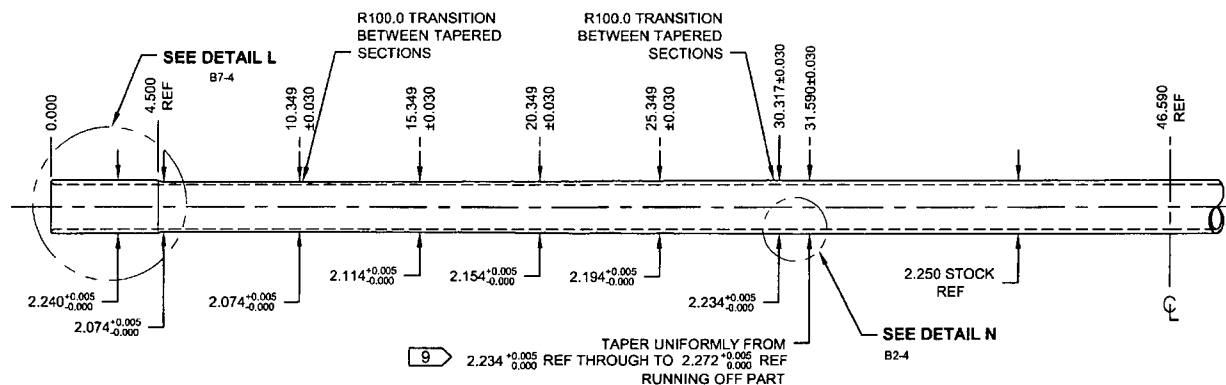
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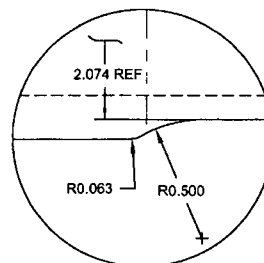
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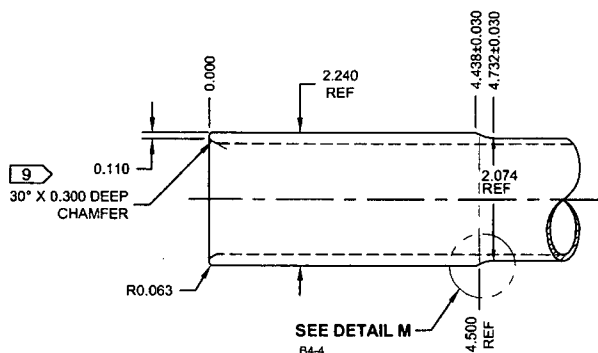
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TURNING DETAIL

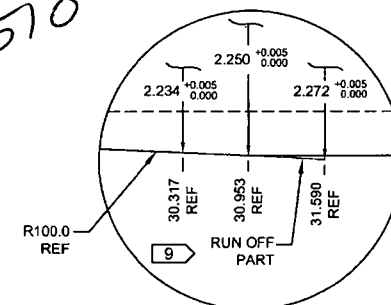


**DETAIL M:
CUFF TRANSITION**
NOT TO SCALE



**DETAIL L:
CROSSTUBE CUFF**
NOT TO SCALE

50578



**DETAIL N:
TAPER RUN-OFF**
NOT TO SCALE

RELEASED

DESIGN	9	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	UP	DRAWING NO.	REV. C
MFG. APPR.	EP	D206-667-141	SHEET 4 OF 4
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